

PUMA AW560/660 PUMA VAW 700/800

Aluminum Wheel Turns



2-axis aluminum wheel turning

Superb customized horizontal aluminum wheel turning centers are designed for high precision and faster machining across a board range of aluminum wheels and to meet demanding specs for higher productivity.

PUMA AW560/660



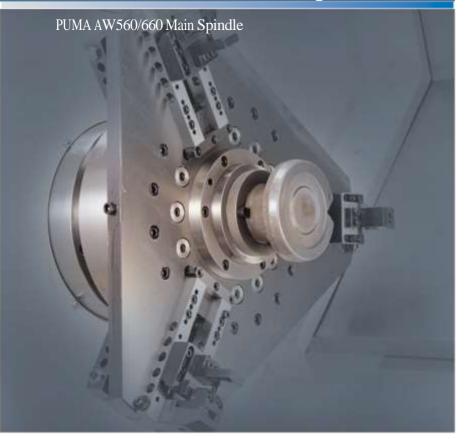
4-axis aluminum wheel turning

Specialized aluminum wheel turning centers, PUMA VAW series redouble the machining productivity with its twin turrets, robust and systemized design construction.

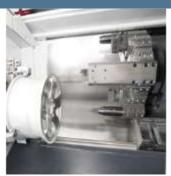
PUMA VAW700/800



PUMA AW Series Main Spindle



AL. Wheel Turning Capacity



PUMA AW560 X-axis travel 20 (24)*2 362 mm

PUMA AW660 Z-axis travel

24 (26)*2 720 mm

 $\frac{\text{Motor}(30 \text{ min})}{37 \text{ kW}}$

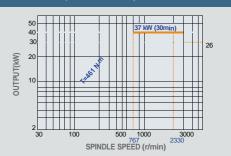
*1: PUMA AW660 & PUMA AW560 opt.

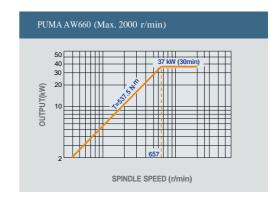


The powerful high-torque spindle motor provides power for heavy stock removal, greatly reducing the number of roughing passes required.

Main Spindle Power-torque diagram

UMA AW560 (Max. 3000 r/min)





*2: The detail specifications should be reviewed before contract.



X-axis travel 16 m/min

Z-axis travel 20 m/min

Turret

No. of tool station 12 station

500 1000 2000

Index time (1-station swiveled) 0.25 s

feed system

Perfect realization of servo driven

Fast indexing turret (indexing time:0.25second) designed for high productivity and take on all kinds of Aluminum Wheels.

High speed & high accuracy cutting



Doosan Al. wheel turn series finish alumininum wheels with improved effeciency, which is guaranteed by up 3000 r/min spindle speed and 0.002mm repeatability.

Shower coolant system (Opt.)



The large volume of pressure coolant system is effectively to remove heat from the aluminum wheel and tool to assure consistent high precision.

Easy chip removal



Mass of chips falls directly onto single-sheet saddle cover below for much more effective handling.

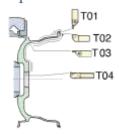
Coolant system



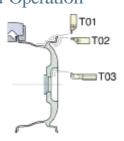
Large-capacity chip flushing coolant system

Machining Example

1st Operation



2nd Operation



Operating Specifications

| Tool | Tools | | Cutting conditions | | | |
|------|-------|---------------------------------------|--------------------|-----------|-------|------------|
| No. | Shape | Holders (Inserts) | N(r/min) | V(m/min) | T(mm) | F(min/rev) |
| T01 | | RF151. 42-2525-60 (N151. 4-800-60-AL) | 2200 | 2620-2618 | 3 | 0.3 |
| T02 | | PCLNR 2525 M12 (CNMG 120412/kW10) | 2200 | 2608-2042 | 3 | 0.3 |
| T03 | | RF151. 42-2525-60 (N151. 4-800-60-AL) | 2200 | 2042-440 | 3 | 0.27 |
| T04 | | S25T-STFCR/16 (TCGX 16T308-AL) | 2200 | 440-408 | 3 | 0.3 |

Operating Specifications

| - | • | | | | | |
|------|-------|---------------------------------------|--------------------|-----------|--------|-------------|
| Tool | | Tools | Cutting conditions | | | |
| No. | Shape | Holders (Inserts) | N (r/min) | V (m/min) | T (mm) | F (min/rev) |
| T01 | | RF151. 42-2525-60 (N151. 4-800-60-AL) | 2200 | 2620-2618 | 3 | 0.3 |
| T02 | | RF151. 42-2525-60 (N151. 4-800-60-AL) | 2200 | 2608-2262 | 3 | 0.15 |
| T03 | | S25T-SDUCR 11-M (DCGX-11T308-AL) | 2200 | 943-408 | 3 | 0.3 |

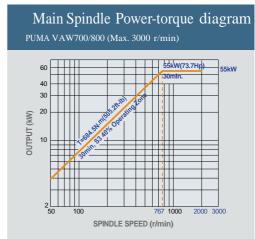


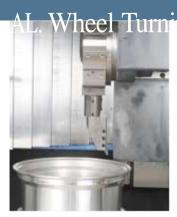
2000 r/min

Motor (30 min)

55 kW (opt: 75 kW)

The high-torque spindle motor provides power for heavy stock removal, greatly reducing the number of roughing passes required.





PUMA VAW700 26.5 (without ACC) PUMA VAW800 28 (without ACC)

X-axis travel Right 570 mm

Z-axis travel Left $570 \, \text{mm}$ Left $550 \, (650)^{*1} \, \text{mm}$ Right 550 (650) mm

1: on VAW800



X-axis travel $16 \, \text{m/min}$

Z-axis travel $16\,\mathrm{m/min}$

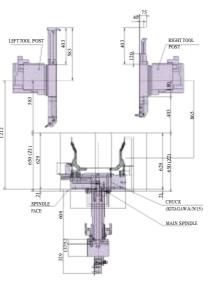


No. of tool station 6+6 station

Index time (1-station swiveled) $0.15 \, \mathrm{s}$

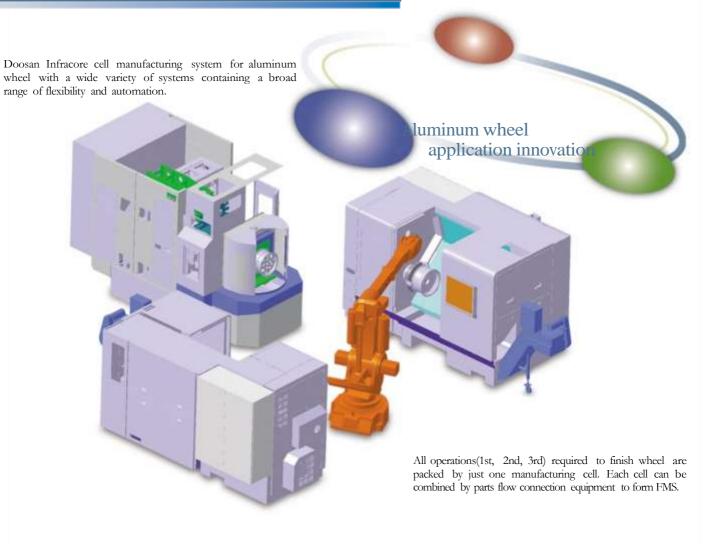
Operator's Panel







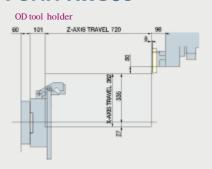
The operator panel is mounted on an adjustable pendant for easy viewing and accessibility during set-up and operation. The layout and location of the panel is ergonomically designed to maximize the efficiency of use and operator's convenience. Comprehensive alarm diagnostics are provided for the machine, control and programming errors.

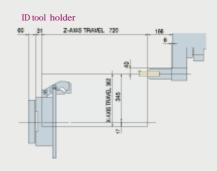


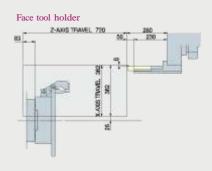
Working Ranges

unit: mm

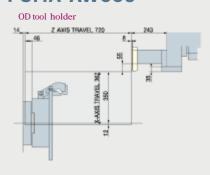
PUMA AW560

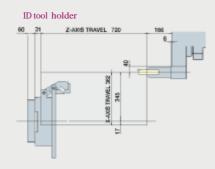


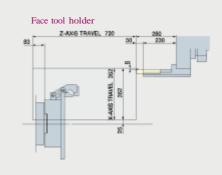




PUMA AW660





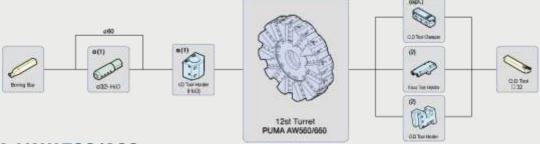


Note) Detail information of VAW700/800 does not included in the catalogue. If the detail information related VAW700/800 needed, please contact your countpartner before contract.

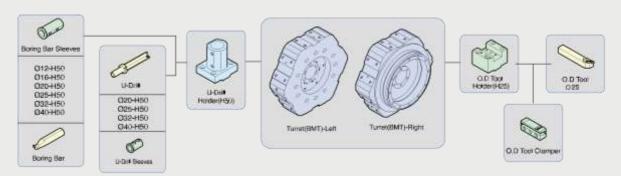
Tooling System





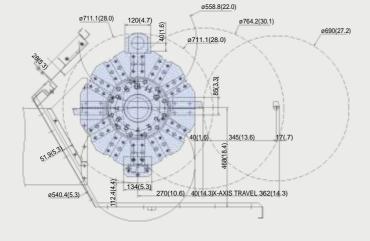


PUMA VAW 700/800

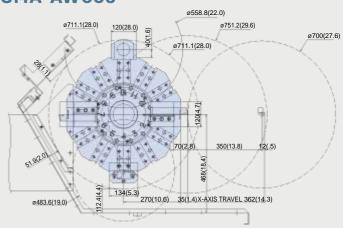


Tool Interference Diagram

PUMA AW560



PUMA AW660

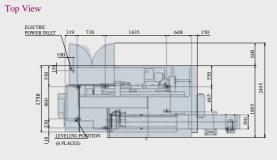


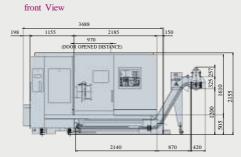
External Dimension

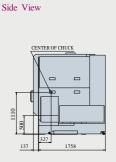
unit: mm

unit: mm

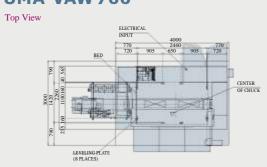
PUMA AW560/660

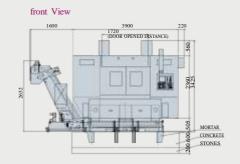


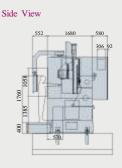




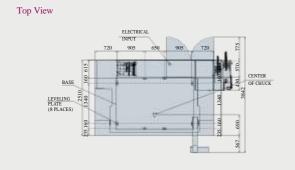
PUMA VAW 700

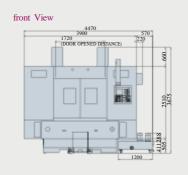


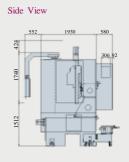




PUMA VAW 800







Machine Specifications

| | Item | | PUMA AW560 | PUMA AW560MF* | PUMA AW660 | PUMA VAW700 | PUMA VAW800 | |
|--------------|---|-------|------------|-----------------------|------------|-------------|-------------|--|
| | Swing over bed | mm | | 830 | | 900 | 1140 | |
| | Swing over saddle mm | | 600 | | | 730 | 970 | |
| Capacity | Max. turning diameter mm | | 550 650 | | | 673 | 711 | |
| | Max. turning length | mm | | 710 | | 330 | 440 | |
| | Recom, wheel size | inch | 20 {24 } | 20 | 24 {26 } | 26.5 | 28 | |
| Carriage | Travel distance X-axis m | | 362 | | | 570 | | |
| Camage | Z-axis mm | | 720 | | | 550 | 650 | |
| | Spindle speed | r/min | 3000 | 2500 | 2000 | 20 | 00 | |
| Main Spindle | Spindle nose ASA | | A2 #8 | | A2 #11 | | | |
| | Spindle bearing diameter (Front) | mm | 160 | 130 | 180 | 150 {180} | | |
| | No. of tool station | | 12st | | | 6st + 6st | | |
| Tool Post | OD tool height mm | | | 32 32 | | | 25 25 | |
| | Boring bar diameter mm | | ø60 | | | ø50 | | |
| | Indexing time (1st swivel) s | | 0.25 | | | 0.15 | | |
| | Rapid traverse X-axis | m/min | | 16 | | | | |
| Feedrate | Z-axis m/min | | 20 | | | 16 | | |
| reediate | Max. cutting feedrate X-axis mm/rev | | 500 | | | | | |
| | Z-axis mm/rev | | 500 | | | | | |
| ACC | Automatic chuck changer (A.C.C) | | | - | | N | /A | |
| | Main spindle motor | kW | 30/37 | 25/30 | 30/37 | 45/55 | | |
| Motors | Servo motor X-axis kW | | 4.0 | | | | | |
| Wiotors | Z-axis kW | | 7.0 | | | 4.0 | | |
| | Coolant pump kW | | 1.5 | | | | | |
| Power Source | Electric power supply (Rated capacity) kVA 53.1 | | | 88.2 | | | | |
| | Machine height | mm | | 2155 | | 3425 | 3675 | |
| Machine | Machine Demension length mm | | 3688 | | | 4470 | | |
| Size | width mm | | 2495 | | 3602 | 3842 | | |
| | Machine weight | kg | 7 | 750 | 8000 | 13000 | 13500 | |
| NC System | | | | Doosan Fanuc i series | | Fanuc | 31i-A | |

*: Mirror Finished Note: { } are optional.

Standard Feature

Air blower*1 Full enclosure chip and coolant shield Linear position transducer for chuck Air gun*1 Hand tool kit, including small clamp detection at loading station*2 Automatic door*1 hand tool for operations Lubrication equipment Coolant supply equipment Hydraulic actuating cylinder Safety precaution name plates Electric power transformer Hydraulic power unit for operations Standard tooling kit Foot switch-chuck Instruction manuals & parts book (tool holders & boring sleeve) Front door interlock Levelling jack screw & plates Work light *1 : VAW700/800

Optional Feature

Additional tool holders & sleeves Air blast for chuck jaw or work cleaning Air conditioner for electric power cabinet

Air finger chucks Air gun

Automatic front door with safety device

Automatic loading & unloading equipment

Chip bucket Chip conveyor

Linear scale for left & right X-axis*1

Oil mist collector Oil skimmer

Pressure switch for chucking

pressure check

Safety edge sensor for auto-door

Semi-dry coolant

Signal tower (yellow, red, green) Special chucks and cylinders

*1: VAW700/800

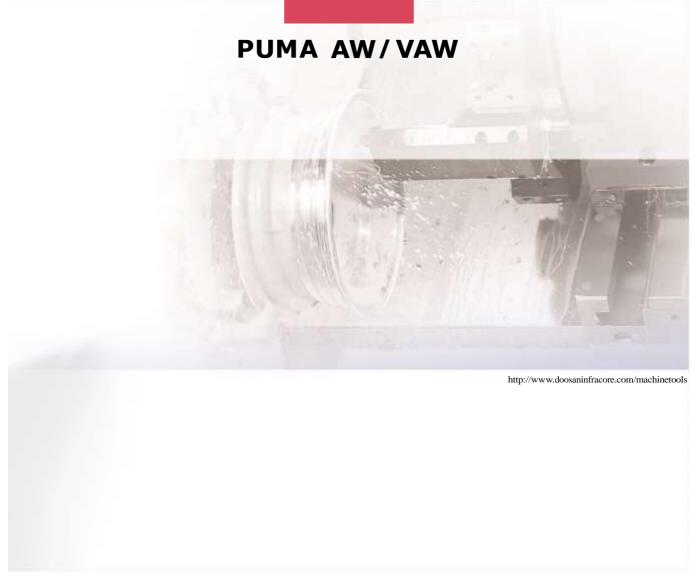
Design and specifications are subject to change without prior notice.

Doosan is not responsible for difference between the information in the catalogue and the actual machine.

NC Specifications

| Controlled axes Simultaneously controlled axes Std. 2 axes | DOOSAN Fanuc i series | Fanuc 31i-A |
|--|-----------------------|---------------------|
| Backlash compensation Follow-up / Chamfering on/off IRV2 control Founctions Functions | X, Z | X1, Z1, X2, Z2 |
| Follow-up / Chamfering on/off IRV2 control Functions Increment system 1/10 Increment sys | 2 axes | 4axes |
| unctions IRV2 control | | |
| Increment system 1/10 | | |
| Least input increment 0.001mm / 0.0001 | | |
| Stored stroke check! Automatic operation(memory) / Buffer register Handle incremental feed XI, X10, X100 Search function Ist, 2nd reference position check / return Greular interpolation Meliple threading / Thread cutting G04 Linear interpolation Multiple threading / Thread cutting retract Thread cutting / Synchronous cutting Feed per minute / Feed per revolution Feedrate override Jog feed override Rapid traverse override Poly 25 / 100 % Spindle orientation Constantant surface speed control M-function M- | | Opt. |
| Automatic operation(memory) / Buffer register | | |
| Handle incremental feed XI, X10, X100 | | |
| Search function Ist, 2nd reference position check / return G27 / G28, - / G30 Continuous thread cutting Dwell Linear interpolation One of the proper product of the p | | |
| Ist, 2nd reference position check / return G27 / G28, - / G30 Circular interpolation G02 Continuous thread cutting Dwell G04 Linear interpolation G01 Multiple threading / Thread cutting Feed per minute / Feed per revolution Feedrate override 0 - 200 % (10% unit) Jog feed override 0 - 200 mm/min Rapid traverse override F0/25 / 100 % Spindle orientation M3 digit M-function M5-function M3 digit M-function M5-function M5-function Spindle speed override O-150 % Absolute / Incremental programming Cansed cycle for drilling / Turning Castom macro Decimal point programming / pocket calculator type decimal point programming Maximum program dimension 9 digits Multi repetitive canned cycle G70-G76 Multi repetitive canned cycle G70-G76 Multi repetitive canned cycle G10 Sub program number / Sequence number O4 digits / N8 digits Programmable data input G10 Sub program call Tape format for FANUC series 10/11 Tape format for FANUC series 15 Work coordinate system selection G52-G59 Auto tool offset Tool monitoring system Direct input of tool offset value measured B Tool geometry / wear compensation T-code function T-code function | | |
| Circular interpolation Continuous thread cutting Dwell Linear interpolation Dwell Continuous thread cutting Dwell Continuous thread cutting Dwell Continuous thread cutting Continuous thread cutting Feed per minute / Feed per revolution Feed rate override Feed per minute / Feed per revolution Feed rate override Jog feed override Spindle orientation Constantant surface speed control M-function M-function M-function Spindle speed override Absolute / Incremental programming Canned cycle for drilling / Turning Castom macro Decimal point programming / pocket calculator type decimal point programming Unctions Multi repetitive canned cycle Optional block skip Program number / Sequence number Od digits / N8 digits N8 digits Programmable data input Sub program call Tape format for FANUC series 10/11 Tape format for FA | O. | |
| Interpolation Continuous thread cutting Go4 | | |
| Devel Go4 | | |
| Linear interpolation Multiple threading / Thread cutting retract | | |
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| Feed Functions Feed per minute Feed per revolution Feedrate override 0 - 2000 %(10% unit) Feedrate override 0 - 2000 mm/min Rapid traverse override F0/25 / 100 % Spindle orientation Fo/25 / 100 % Spindle orientation M3 digit M4 function M3 digit M4 function M3 digit M4 function M5 function M5 function M5 function M6 function M7 function M7 function M8 digit M6 function M7 function M8 digits | | |
| Feedrate override Jog feed override Spindle orientation Constantant surface speed control Multimate Spindle orientation Spindle Functions Absolute / Incremental programming Canned cycle for drilling / Turning Caustom macro Decimal point programming / Direct drawing dimension programming Maximum program dimension Jorical drawing dimension programming Multi repetitive canned cycle Multi repetitive canned cycle Jopional block skip Program number / Sequence number Program at Input Sub program call Tape format for FANUC series 10/11 Tape format for FANUC series 15 Work coordinate system selection Jorical input of tool offset value measured B Tool geometry / wear compensation Tool offset pairs Tool offset value counter input Background editting Expanded part program editing No. of Registered programs Part program editing / Program protect Part program editing size* Josiphy of spindle speed and T-code at all screen Help function Servo setting screen / Spindle setting screen Tool path graphic display JO interface Muncy card input and output Reader puncher control CH1 interface | | |
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| - reader penetier condor | | |
| Ethernet function Embedded ethernet function | n | |
| Other Functions MDI / Display unit | 10.4 Color TFT LCD | 10.4 Color TFT LCD |
| PMC system | To., Color II I I CD | TOTAL COLOIT TELECO |

^{*1:} Standard Part program length is different on export condition. On the addition of optional functions, its length can be reduced.



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